

ANNEXURE-A

Date-03.10.2026

PI NO:-220260078

DESCRIPTION:-MACHINING OF 4 NOS. PELTON RUNNER AS PER DRAWING NO. 120407262000803 (REV.00)FROM FORGED STAINLESS STEEL DISC (DRAWING.NO.120407262000803,REV.00).

SCOPE OF WORK:

1. Raw material for Pelton Runner will be issued from BHEL Bhopal after submitting Bank Guarantee by the Vendor.
2. The material of the forged disc is ASTM A473 M Type S41500.
3. BHEL will furnish a 3D Model for bucket profile and hub details after PO placement.
4. BHEL will furnish inspection sheets of Pelton Runner after PO placement.
5. Pelton Runner having 20 nos. Buckets will be machined from single disc forging with help of a 5-Axis CNC machine.However, Vendors are free to machine these Pelton Runners on equivalent 5-Axis CNC machine(3-Axis CNC machine with programmable head) ,but the final dimension should be as per the drawing.
6. Runner forging shall be supplied with fully finished machined ground and polished buckets. However, coupling faces and central bore should be in rough machined condition as shown in section A-A of drawing no.120407262000803(rev.00).
7. Coupling bores machining will be done at BHEL Bhopal, not in the scope of Vendor.
8. Vendor will supply two sets of templates (as per inspection sheets).One set of templates will be dispatch with first runner & the other set with the last runner.
9. Before the start of runner machining , Vendor to ensure the latest revision of drawings and to be confirmed from BHEL Bhopal.
10. In case of any doubt during machining , vendor to consult BHEL Bhopal.
11. Vendor to follow all technical requirements shall be as per drawing 120407262000803(rev.00)
12. Delivery within 150 days per Runner after issue of material.
13. Indent quantity to be split among two successful bidders in the ratio of 3:1. In case of only one successfully qualified bidder,order for all 4nos. shall be placed on that successful bidder.

COMMON POINTS:

- 1) QA plan applicable.
- 2) Vendor to follow all technical requirements as per drawing 120407262000803(rev.00).
- 3) Required tools and fixtures will be arranged by the Vendor.
- 4) Any checking gauge/measuring gauge will be arranged by the Vendor.
- 5) Inspection will be done at Vendor's work By BHEL/BHEL's costumer before dispatch.
- 6) Transportation to & fro from BHEL Bhopal works will be in the Vendor's scope.
- 7) Scrap(Approx 5698 kg. per Runner, RM wt approx. 8513 kg. FM wt approx 2815 kg.) to be retained by the Vendor free of cost and only GST on scrap will be deducted from Vendor invoices .

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Technical Pre-Qualification Requirements for Machining of PELTON RUNNER,

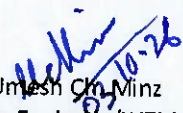
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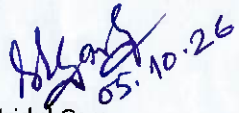
Required machining of 4 no.Stainless steel (ASTM A473.M Type S41500) Pelton Runner as per drawing 120407262000803 rev.00(OD 1852.2 mm, weight 2815 kg.) from forged Disc(Drawing no. 120407262000803 rev. 00, weight-8513 kg, OD 1875 mm) & as per **Annexure-A**.

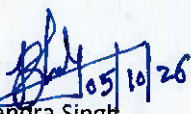
Following are the minimum eligibility requirements for machining of Pelton Runner for qualification of vendors.

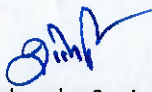
- (1) Availability of 5-Axis CNC machine / Equivalent of 5-Axis CNC machine (3-Axis CNC machine with programmable head), Machine make with specification & photo are required. Vendor to ensure the capacity of machine to accommodate above forged disc.
- (2) Only those vendors should quote who have experience for machining of at least one number Pelton Runner buckets from forged disc of size (runner final OD) 750 mm. or higher in past 10 years(on the date of opening of this tender). They have to submit an unpriced copy of Purchase Order, experience & completion certificate and drawing in support of dispatch date. The PO and completion certificate should be within last 10 years from the date of tender opening (techno-commercial). In case of partial completion PO, lot completion certificate is required.
- (3) Availability of Crane facility for lifting of 12 ton job or more considering factor of safety.Documents to be submitted by vendor.
- (4) Availability of surface finish measuring instruments. Instruments make with spec & photo are required.
- (5) Vendor should be ready to accept a secrecy clause of maintaining strict confidentiality of the model/profile/data/information related to this purchase order. For this a declaration to be furnished by vendor on company letterhead signed by competitive authority.


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